

Date: Thursday, 24/08/2006 3:21:58 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28336
Estimate Number : 12286
P.O. Number : N/A
This Issue : 24/08/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : PURCHASED PARTS
Previous Run : 27033
Written By : W
Checked & Approved By : W
Comment : Est Rev:A New Issue 06-02-09 JLM

Drawing Name : ROUND BILLET, ALUMINUM
Part Number : D6103003
Drawing Number : D6103 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 31/08/2006 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1920

C206108125

a) Description: Alluminum round billet

b) Ø3.500" x 12.500" long

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Material: 7075-T7351 (QQ-A-225/9)

Material certification required

(40)

2.0 D6103003P round alum billet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)
alum billet

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

206/9/4

(40)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

J.G

06/09/07 40

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

206/9/4 (40)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/09/11
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 24/08/2006 3:21:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ROUND BILLET, ALUMINUM

Job Number: 28336

Part Number: D6103003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

10

06/09/11

Job Completion



C 206/09/08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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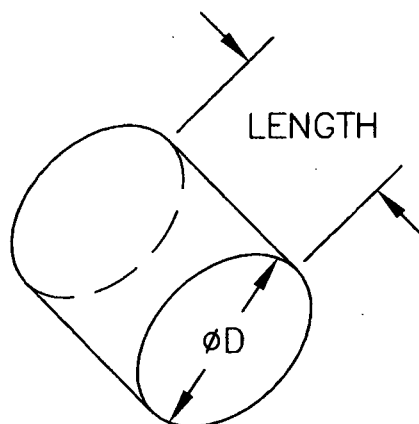
NOTE: Date & initial all entries



| | | | |
|------------------------|-------------------------|--|------------------------|
| DESIGN P41 | DRAWN BY P41 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D6103 | Rev. B SHEET 1 OF 1 |
| DATE 06.01.31 | | TITLE ROUND BILLET, ALUMINUM | SCALE NTS |
| A | 01.04.10 | NEW ISSUE | |
| B | 06.01.31 | ADD D6103-003 | |

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07 [Signature]



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

| Part No. | Alloy | D (Diameter) | Length |
|-----------|--|-----------------|--------|
| D6103-001 | 7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9) | Ø3.250 | 12.50 |
| D6103-003 | 7075-T7351 (QQ-A-225/9) | Ø3.500 | 12.50 |
| | | | |
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Certified Inspection Report

08/22/06
18:37:35

Alcoa Global Cold Finished Products
Massena Operations
Park Avenue East, Massena, NY 13662



Customer **Castle A M & Co** Customer P.O. No. **01-20939** Customer Part No. **(8808)** Alcoa Order No. **MMC-73070-001** Govt. Contract No. **000153235**

Ship To **A. M. Castle & Company**
3400 North Wolf Road
Bay #7
Franklin Park, IL 60131

We hereby certify that the material covered in this report has been inspected in accordance with, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and have the mechanical properties shown on the face of this sheet. Manufactured under an ISO/9000 registered quality management system.

Melted and manufactured in the USA.

James A. Brock, Quality Assurance Manager

Date Shipped **08/22/06** Weight Shipped **1,123 lbs** Product **CFRB-CF ROD Specific Length** BOL **000153235**

Alloy - Temper **7075-T7351** Size **3.50000 IN** Shape **DIA** Config **12 FT** QRR

Specifications:

A97075-11 Rev 9 w/exceptions & comments per J Brock ltr dtd 5/16/06

Material conforms to T73 requirements

Minimum mechanical properties to apply:

68 KSI Tensile Strength

58 KSI Yield Strength

10% Elongation

AMS 4124D (Except Size)

QQA-225/9E (Except Size)

ASTM B211-03 (Except Size)

AMS-QQA-225/9 (Except Size)

CASTLE METALS FP
DATE REC'D **8/24/06** IAC **8808**
APPROVED BY: **KC**

Product produced and marked to the requirements of AMS-QQ-A-225/9 also meets the requirements of QQ-A-225/9.

Product produced and marked to the requirements of QQ-A-225/9 also meets the requirements of AMS-QQ-A-225/9.

| TEST REQUIREMENTS | Test U.T.S. | Test T.Y.S. | Test %Elong | Test Cond | Test | Test | Test | Test | Test |
|-------------------|----------------|----------------|----------------|--------------|------|------|------|------|------|
| Max: | | 67.9 | | | | | | | |
| Min: | 68.0 | 56.0 | 10.0 | 38.0 | | | | | |

| Test Results | Test U.T.S. | Test T.Y.S. | Test %Elong | Test Cond | Test | Test | Test | Test | Test |
|------------------|----------------|----------------|----------------|--------------|------|------|------|------|------|
| Lot / Work Order | | | | | | | | | |
| MA006063248 | 71.3 | 59.7 | 13.0 | 40.7 | | | | | |
| Max: | | | | | | | | | |
| Min: | 71.3 | 59.7 | 13.0 | 40.7 | | | | | |

TEST ABBREVIATIONS

U.T.S. Ultimate Tensile Strength KSI

Cond Conductivity % IACS

T.Y.S. Tensile Yield Strength KSI

%Elong Elongation % in 2"

Aluminum Association Chemical Composition Limits (in Weight %)

| ALLOY | %SI | %FE | %CU | %MN | %MG | %CR | %ZN | %TI | %Others | %Others | %AL |
|-------|------|------|-----|------|-----|------|-----|------|---------|---------|-----|
| 7075 | 0.40 | 0.50 | 2.0 | 0.30 | 2.9 | 0.28 | 6.1 | 0.20 | 0.05 | 0.15 | Rem |
| MAX | | | | | | | | | Each | Total | |
| MIN | | | 1.2 | | 2.1 | 0.18 | 5.1 | | | | |

Actual Started Chemistry

| LOT/WORK ORDER | %SI | %FE | %CU | %MN | %MG | %CR | %ZN | %TI | %OE | %OT | %AL |
|----------------|------|------|-----|------|-----|------|-----|------|---------|---------|-----|
| MA006063248 | 0.07 | 0.23 | 1.8 | 0.02 | 2.5 | 0.20 | 5.9 | 0.02 | LT 0.05 | LT 0.15 | Rem |
| MAX | | | | | | | | | | | |
| MIN | 0.06 | 0.22 | 1.5 | 0.02 | 2.3 | 0.20 | 5.5 | 0.02 | | | |

08-25-06 01:00 FROM-

T-600 P007/022 F-1/25

Certified Inspection Report

08/22/06
16:37:35

Alcoa Global Cold Finished Products
Massena Operations
Park Avenue East, Massena, NY 13662



| | | | | |
|-----------------|-------------------|-------------------|-----------------|--------------------|
| Customer | Customer P.O. No. | Customer Part No. | Alcoa Order No. | Govt. Contract No. |
| Castle A M & Co | 01-20939 | (8808) | MMC-73070- -001 | |

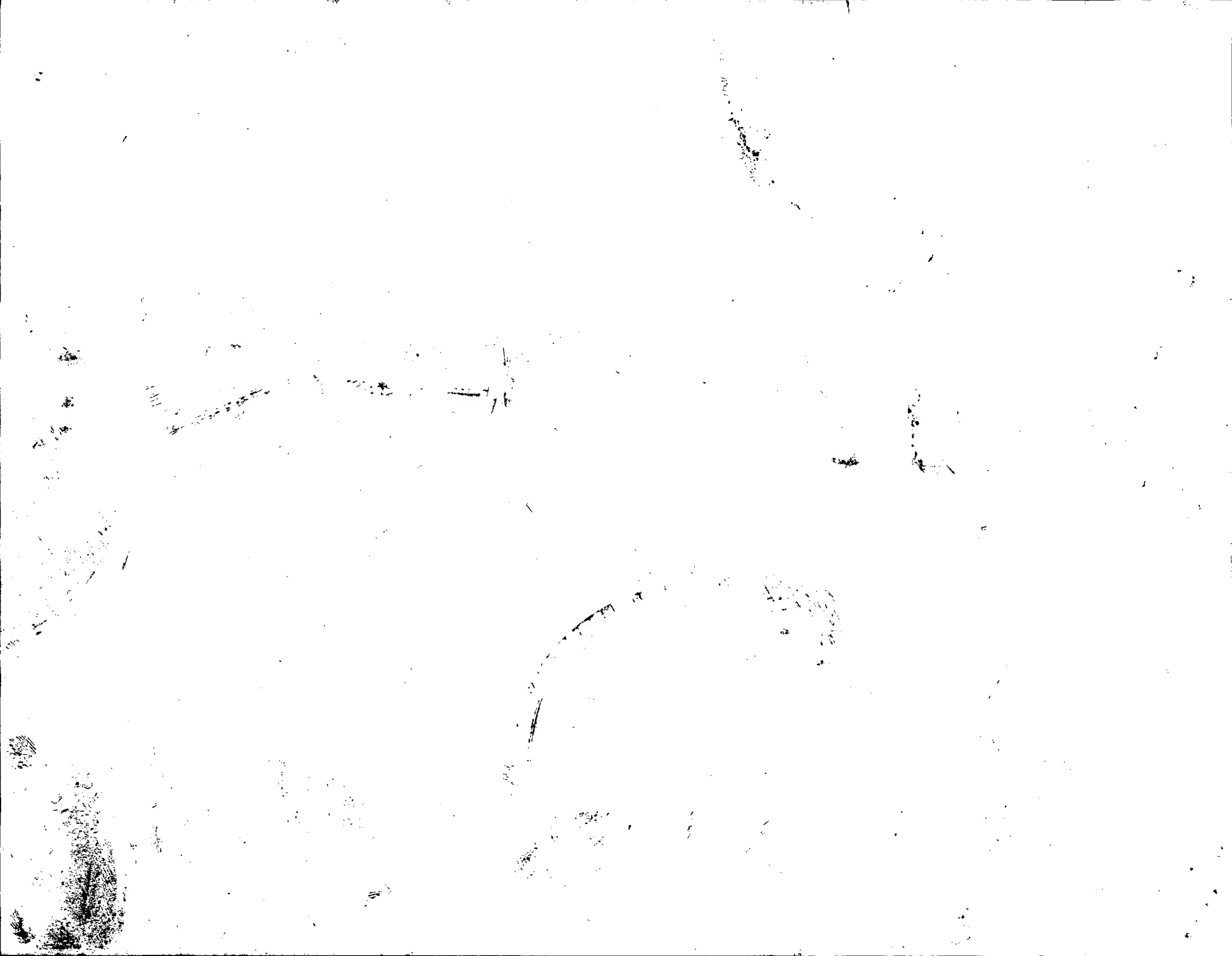
NOTES:

Mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product.

This alloy meets the requirements of EU 2002/95/EC (RoHS) and EU 2000/53/EC for lead, mercury, cadmium and hexavalent chromium.

08-25-'06 01:00 FROM-

T-600 P008/022 F-725



Date: Wednesday, 16/08/2006 1:12:41 PM
 User: Linda Lacelle

Process Sheet

| | |
|--|--|
| Customer : CC-DAR01 Dart Aerospace Ltd. | Drawing Name : DSI 9052013 |
| Job Number : 28202 | |
| Estimate Number : 10804 | |
| P.O. Number : N/A | Part Number : DSI 9052013 |
| This Issue : 16/08/2006 S.O. No. : N/A | Drawing Number : RTN 490 <i>J</i> |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : N/A | Drawing Revision : N/A |
| Previous Run : 00015 | Material : N/A |
| Written By : _____ | Due Date : 23/08/2006 |
| Checked & Approved By : _____ | Qty: 1 Um: Each |
| Comment : _____ | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT

2.0

DSI 9052013

Quick Release Kit 350/5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Quick Release Kit 350/5
 ORIGINAL B/N 20057

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 REPACKAGE PER PPP

4.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 INSPECT LEVEL 21

Job Completion



u 2609-08

Date: Wednesday, 16/08/2006 1:36:11 PM
 User: Linda Lacelle

Process Sheet

| | |
|--|--|
| Customer : CC-DAR01 Dart Aerospace Ltd. | Drawing Name : D350-727-011 |
| Job Number : 28205 | |
| Estimate Number : 10804 | |
| P.O. Number : N/A | Part Number : D350727011 |
| This Issue : 16/08/2006 S.O. No. : N/A | Drawing Number : RTN 504 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : | Drawing Revision : N/A |
| Previous Run : 00015 | Material : N/A |
| Written By : | Due Date : 23/08/2006 Qty: 1 Um: Each |
| Checked & Approved By : | |
| Comment : | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|------------|-------------------------|
| 1.0 | D350727011 | Wearplate Kit, Standard |
|-----|------------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Wearplate Kit, Standard
 ORIGINAL B/N 27619

| | | |
|-----|-----|------------------------------|
| 2.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT RTN 504

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 REPACKAGE PER PPP
 USING NEW B/N (NEW LABEL REQ'D)

| | | |
|-----|----|------------------|
| 4.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Job Completion



u 060908